

**Work Order ID 53900**

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November 23, 2009 1:22:22 PM

Item ID: D2739

Accept



Revision ID: D

Setup

Start



Item Name: 350 I Beam

Stop



Start Date: 23/11/2009 Start Qty: 11.00



Cust Item ID:

Required Date: 27/11/2009 Req'd Qty: 11.00



Customer:

Reference:

Approvals: Process Plan: *RL*Date: *09/11/23*

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run

Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2739	Rev D								

100 *11 09/11/24*

Skidtubes

Skidtubes *11 09/11/24*Skidtubes *11 09/11/24*  
Memo 0.00  
1-Cut D2600-5 to length as per Dwg D2739.□2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739□3-Use uni-bit to open holes to finish size as per Dwg D2739.□4-Bevel Fwd end of extrusion and Deburr holes and ends.□5-Dburr110 *9-11-25 11* QC *9-11-25 11*Quality Control *9-11-25 11*120 *11/11/25 11* HandFinish *11/11/25 11*Hand Finishing *11/11/25 11*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID: 53900**

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November 23, 2009 1:22:23 PM

Item ID: D2739

Accept



Setup Start



Revision ID: D

Stop



Item Name: 350 I Beam

Start Date: 23/11/2009 Start Qty: 11.00



Cust Item ID:

Required Date: 27/11/2009 Req'd Qty: 11.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



QC3- Inspect Part Finish

0.00

11 11/11/25

QC



Quality Control

Memo

0.00

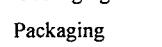
140

Identify as per dwg & Stock Location: L6

0.00

11 11/11/25

Packaging



Memo

0.00

Packaging

150



QC21- Final Inspection - Work Order Release

0.00

QC



Memo

0.00

Quality Control

09/11/26 JF

MF 09-11-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# → Picklist Print

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November 23, 2009 1:22:29 PM

Work Order ID: 53900



Parent Item: D2739RevD



Parent Item Name: 350 I Beam

Start Date: 23/11/2009

Required Date: 27/11/2009

Comments:

Start Qty: 11.00

Required Qty: 11.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2600-5-108RevD1		Manufactured	No			100	Each	258.0000	11.0000			

Extrusion 'I Beam' thin



## Warehouse

### Location

#### Main Warehouse

ST	258
29985	1
38589	9
47814	248

### Loc Qty

### Loc Code

11 49/1124

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

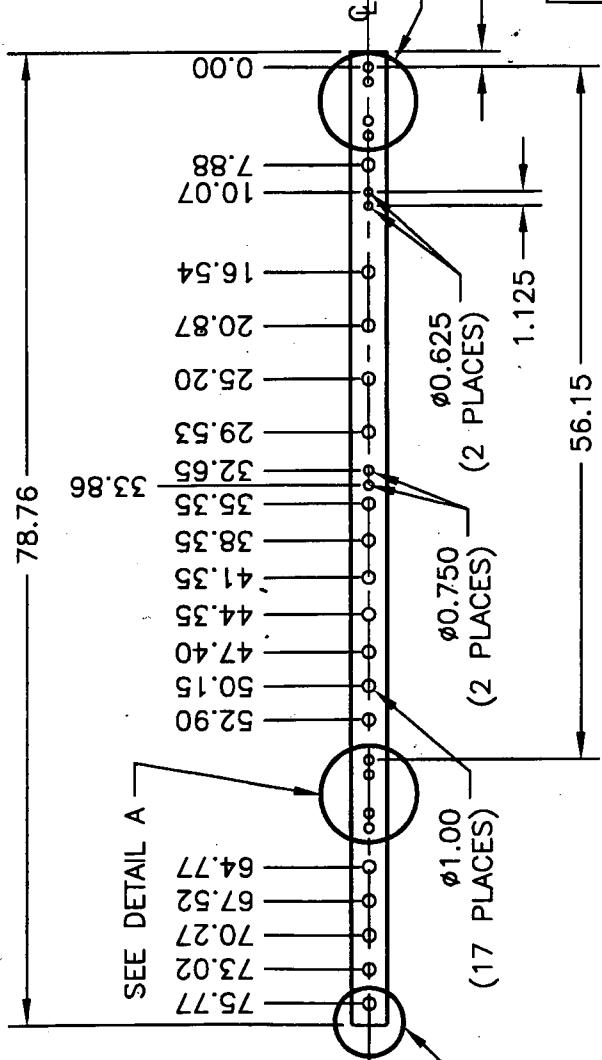
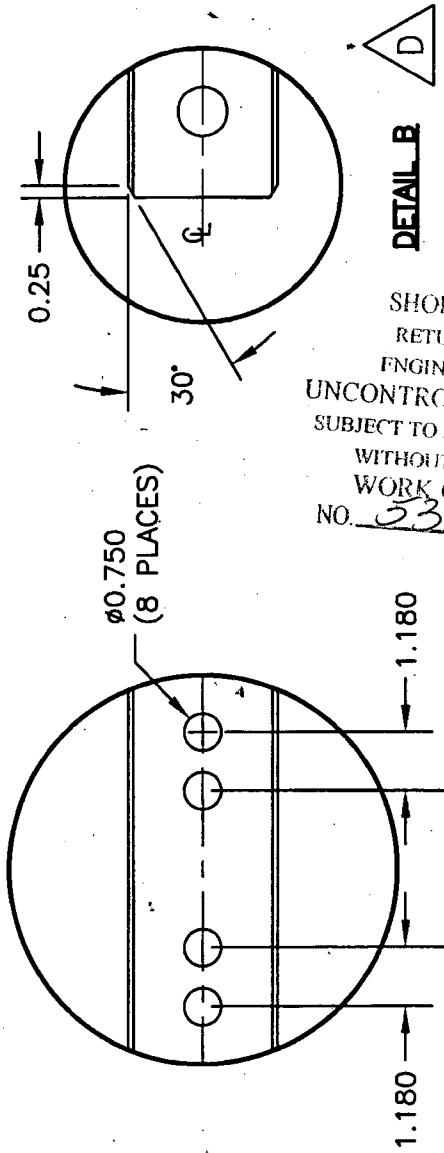
NOTE: Date & initial all entries

**DART**

DESIGN <i>PH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>PH</i>	APPROVED <i>JH</i>	DRAWING NO. D2739
DATE 07.05.29		REV. D SHEET 1 OF 1
		SCALE 1:15
A	98.04.16	NEW ISSUE
B	98.11.18	CHANGE HOLES FOR COMPATABILITY WITH AIRCRUISER FLOATS
C	06.01.05	ADD/MOVE HOLES FOR COMPATABILITY W/APICAL FLOATS
D	07.05.29	ADD BEVEL TO FWD END; ADD DETAIL B

**RELEASED**

08.07.20

**D2739 WEB**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMNT  
WITHOUT NOTICE  
WORK ORDER  
NO. 53900

*Bl 04-11-28*

**NOTES:**

- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRIC ABOUT

*53900*

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